



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5355-041
Job Sheet 190743



Part No: D5355-041

Job Qty: 2 pcs

DAS
21
9-89

Part Name: Aft Clamp Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 2/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

DWG. Rev. C
AFB H/02/14

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	2 pcs	2/27/19	2/27/19	0.00	0.01	Bandsaw - 1	19-04-25
110	HAAS 5 Axis - B4B	2 pcs	2/27/19	2/27/19	1.21	0.86	HAAS - 5 - B4B	19-04-25
120	QC 2	2 pcs	2/27/19	2/27/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	19-04-25
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	



Container No: S175180



Part: D5355-041

Job No: 190743

Serial No/Batch: S175180

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/25/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

130	QC 8	2 pcs	2/27/19	0.00 0.00	QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 8	D. 19-04-30
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
140	Outsource - 4 - Anodize	2 pcs	2/27/19		ATG001-VC	10
150	Packaging 2-1 - Receive - B4B	2 pcs	2/27/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	

D. 19-04-30

2019-05-02

MAY 21 2019

155 QC 6	2 pcs	2/27/19	0.00 0.00	QC 6 - 42	DAS
				QC 6 - 9	MAY 28 2019 40
				QC 6 - 68	9-89
				QC 6 - 61	
160 Small Fab - 2 - B4B	2 pcs	2/27/19	0.00 0.41	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	58 MAY 30 2019
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
170 QC 5	2 pcs	2/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	DAS
				QC 5 - 50	JUN 11 2019 40
				QC 5 - 30	9-89
180 Packaging 3-1 - Stock - B4B	2 pcs	2/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC. ST 158
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
190 QC 21 - SA	2 pcs	2/27/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-59
				QC 21 - SA - 53	JUN 11 2019

Part Op 100 - Cut Blanks at 6.200"

Descriptions: 110 - (HAAS CNC vertical machine #5), 1-Machine per folio FB434 DWG REV: C FOLIO REV: AA 2- deburr and break all sharp edge as per dwg

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O : _____ Black Anodize as per Dwg D5355 Certification of Conformity is required.

150 - (Receive & Inspect for Damage & Mat'l Certs), Certification of Conformity is required.

155 - (QC6- All purchased or subcontracted products)

160 - Assemble as per dwg. -Secure nuts as per dwg. (Note #8) -Apply proseal as per dwg.(Note #9)

Batch: _____ Exp. date: _____

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X4.500	6061-T6 Bar 1.25 X 4.50	1.0340 ft (.517 ea)	100-Bandsaw - 1	S13147 3 4.687 ft
D5316-1 <u>ST153</u>	T-Bolt Strap <u>S187147</u>	2 Ea (1 ea)	160-Small Fab - 2 - B4B	- S166873 3 4.687 ft
D5351-1 <u>GA132</u>	T-Bolt Spacer	4 pcs (2 ea)	160-Small Fab - 2 - B4B	S145898
MS21043-3 <u>ST302</u>	Nut <u>S142102</u>	4 Ea (2 ea)	160-Small Fab - 2 - B4B	S12179 X 16
NAS1149D0332J <u>ST264</u>	Washer	4 Ea (2 ea)	160-Small Fab - 2 - B4B	S161325 S197122 X
				S156763

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X4.500	1	12	0
160-Small Fab - 2 - B4B	D5316-1	2	24	0
	D5351-1	4	67	0
	MS21043-3	4	1,316	0
	NAS1149D0332J	4	2,636	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	190743
Description: Support		Part Number:	D5355-1
Inspection Dwg: D5355	Rev: C	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	.998	/		Vern M/O	
0.50	+/-0.030	.498	/		Vern M/O	
Ø0.204	+0.005/-0.001	Ø.204	/		Vern M/O	
0.22	+/-0.030	.222	/		"	
0.204	+/-0.010	.204	/		"	
0.274	+/-0.010	.271	/		"	
0.31	+/-0.030	.318	/		"	
0.20	+/-0.030	.212	/		"	
0.33	+/-0.030	.330	/		"	
10°	+/-0.5°	10°	/		C-Aquare	
R0.13	+/-0.030	R.125	/		R-G	
20°	+/-0.5°	20°	/		C-Aquare	
R0.20	+/-0.030	R.200	/		R-G	
0.56	+/-0.030	.560	/		Vern M/O	
0.40	+/-0.030	.401	/		"	
0.21	+/-0.030	.215	/		"	
R0.40	+/-0.030	R.400	/		R-G	
0.13	+/-0.030	.123	/		Vern M/O	
R0.29	+/-0.030	R.270	/		R-G	
0.15	+/-0.030	.148	/		Vern M/O	
1.28	+/-0.030	1.275	/		"	
0.13	+/-0.030	.123	/		"	
R0.25	+/-0.030	R.250	/		R-G	
1.200	+/-0.010	1.200	/		Vern M/O	
2.00	+/-0.030	2.001	/		"	
0.40	+/-0.030	.400	/		"	
0.50	+/-0.030	.500	/		"	
0.500	+/-0.010	.500	/		"	
Ø0.257	+0.006/-0.001	Ø.259	/		"	
5.01	+/-0.030	5.015	/		"	
R0.30	+/-0.030	R.300	/		R-G	
0.30	+/-0.030	.300	/		Vern M/O	
0.25	+/-0.030	.250	/		"	
R0.13	+/-0.030	R.125	/		R-G	
0.150	+0.015/-0.000	.153	/		Vern M/O	
0.250	+/-0.015	.249	/			
R0.13	+/-0.030	R.125	/		R-G	
0.65	+/-0.030	.649	/		Vern M/O	

Measured by:	<i>[Signature]</i>	Checked by:	B.A	QC Inspector:	
Date:	19/04/24	Date:	19-04-30	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	18.06.12	New Issue	MG/KJ	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043351



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043351

PO Date: 5/2/19

Due Date: 5/10/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193367	RBE350A93-3500-00-1	Body (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	-	5/24/19	26 pcs	0 pcs	26 pcs	\$5.97/pcs	\$155.22
2	190743	D5355-041	Aft Clamp Assembly : Various STC's Issue P/O : _____ Black Anodize as per Dwg D5355 Certification of Comformity is required.	Firmed	-	5/24/19	10 pcs	0 pcs	10 pcs	\$5.97/pcs	\$59.70
3	191995	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	5/24/19	24 pcs	0 pcs	24 pcs	\$9.10/pcs	\$218.40
Grand Total:											\$433.32

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043351



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

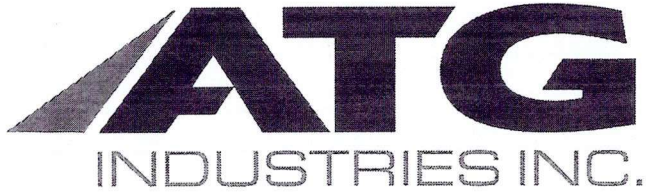
A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

A handwritten signature in black ink, appearing to be "KH" or similar, with a large, sweeping flourish underneath.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/15/19 9:44 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917827

Date: 16-May-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
26 ea	Part: RBE350A93-3500-00-1 Body Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (4 - 1 mils) Water Sealant Job: 25120 PO: POHB043351	Rev: 3A Line: 1	RECEIVED MAY 17 2019 DART AEROSPACE LTD.
10 ea	Part: D5355-041 Aft Clamp Assembly Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (4 - 1 mils) Job: 25121 PO: POHB043351	Rev: C Line: 2	RECEIVED MAY 17 2019 DART AEROSPACE LTD. DAS 40 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 16 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			